

INCH-POUND

MIL-DTL-52525/8B

30 June 1998

SUPERSEDING

MIL-F-52525/8A

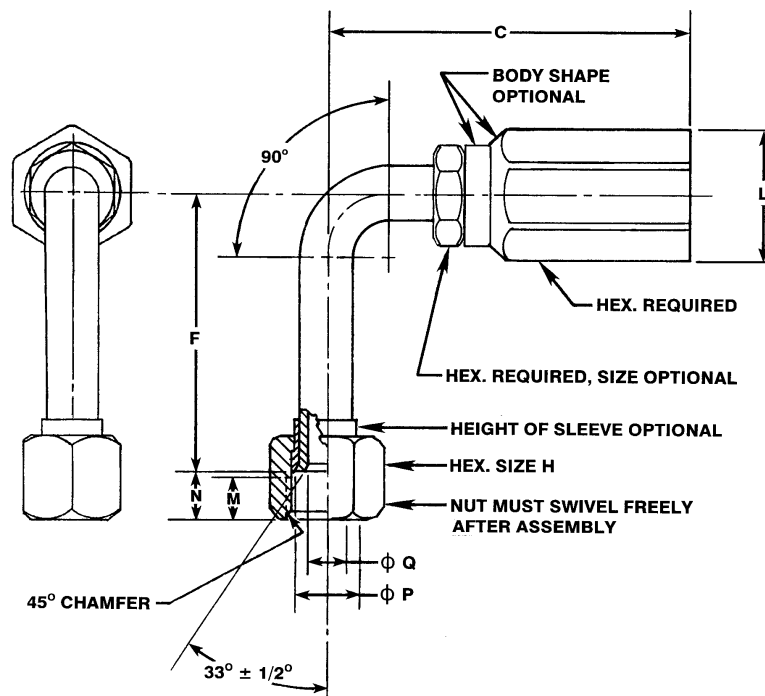
30 June 1987

## DETAIL SPECIFICATION SHEET

### FITTINGS, HOSE, SCREW-ON TO 37° FLARE FEMALE SWIVEL, 90° BENT TUBE, LONG DROP, TYPE 100R1

This specification is approved for use by all Departments and  
Agencies of the Department of Defense.

The requirements for acquiring the product described herein shall consist of this  
specification sheet and MIL-DTL-52525. The fitting described herein are for use with  
MIL-DTL-52471, type 100R1, single wire braid hose.



#### NOTES:

1. DIMENSION P TO BE CONCENTRIC WITH DIMENSION Q WITHIN 0.015 FIM
2. Q=BORE DIAMETER

FIGURE 1. Fitting, hose, screw-on to 37° flare, 90° bent tube, long drop.

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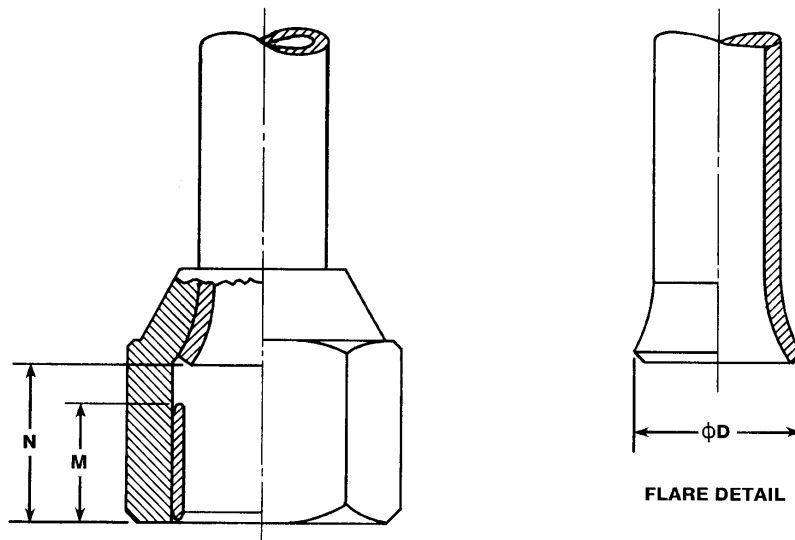


FIGURE 2. Alternate termination radial flare.

TABLE I. Dimensions for type 100R1 fittings. 1/

Part number	Hose dash no.	Hose I.D.	Tube dash no.	Tube O.D.	Thread size	C Maximum	F Maximum	H Hex size
M52525/8-4-4	4	1/4	4	1/4	7/16-20	2.63	1.86	9/16
M52525/8-4-5	4	1/4	5	5/16	1/2-20	2.67	1.86	5/8
M52525/8-6-6	6	3/8	6	3/8	9/16-18	3.03	2.24	11/16
M52525/8-8-8	8	1/2	8	1/2	3/4-16	3.56	2.49	7/8
M52525/8-8-10	8	1/2	10	5/8	7/8-14	3.78	2.63	1
M52525/8-12-12	12	3/4	12	3/4	1-1/16-12	4.28	3.79	1-1/4
M52525/8-16-16	16	1	16	1	1-5/16-12	5.20	4.39	1-1/2

1/ All dimensions not shown shall conform to SAE J516.

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TABLE I. Dimensions for type 100R1 fittings - Continued. 1/

Part number	L Maximum	M Minimum	N +0.030 -0.000	P ±0.005	Q Minimum
M52525/8-4-4	0.87	0.300	0.344	0.295	0.11
M52525/8-4-5	0.87	0.331	0.375	0.355	0.11
M52525/8-6-6	1.09	0.333	0.375	0.435	0.26
M52525/8-8-8	1.20	0.375	0.422	0.570	0.38
M52525/8-8-10	1.20	0.461	0.500	0.680	0.38
M52525/8-12-12	1.59	0.469	0.562	0.850	0.57
M52525/8-16-16	2.02	0.563	0.594	1.000	0.78

1/ All dimensions not shown shall conform to SAE J516.

TABLE II. Dimensions for alternate termination. 1/

Tube size	D		M	N
	max	min	Minimum	Minimum
1/4	0.360	0.340	0.295	0.375
5/16	0.430	0.400	0.295	0.375
3/8	0.490	0.460	0.297	0.385
1/2	0.660	0.630	0.339	0.438
5/8	0.790	0.760	0.409	0.521
3/4	0.950	0.920	0.464	0.594
1	1.200	1.170	0.495	0.625

1/ Dimensions C, F, H, and Q, shall be in accordance with table I.

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TABLE III. Maximum operating pressures of fittings.

Hose I.D.	PSI
1/4	2750
5/16	2500
3/8	2250
1/2	2000
5/8	1500
3/4	1250
1	1000

TABLE IV. Over-tightening torque for swivel nut.

Tube O.D.	Torque
	inch pounds (in-lb)
1/4	135
5/16	180
3/8	270
1/2	450
5/8	650
3/4	900
1	1200

REQUIREMENTS:

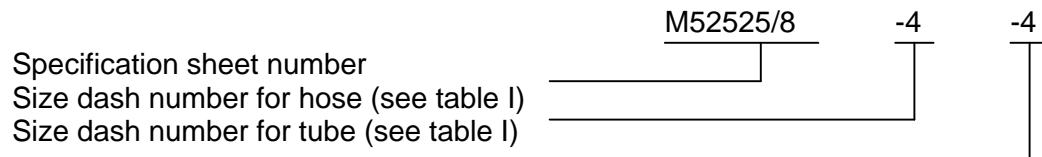
1. Fittings shall be accordance with figure 1 and table I, III, and IV. The use of alternate termination flare as shown in figure 2 and corresponding dimensions of table II is at the option of the contractor.
2. Materials and finishes shall be as specified in MIL-DTL-52525.
3. Marking shall include the manufacturer's name or trademark, size, and hose identifier R1. Location of marking is optional.

## MIL-DTL-52525/8B

### NOTES:

1. Dimensions are in inches.
2. Part number.

Example of a Military part number: M52525/8-4-4



### CONCLUDING MATERIAL

Custodian:  
Army - AT  
Air Force - 99

Preparing activity:  
DLA - CC  
(Project 4730-0859-08)

Review activities:  
Air Force - 82  
Army - AR